Work Order Tuesday, July 19, 2												Page 1
Revision ID:	03413-1 ing			Accept					Setup	Start Stop		
	/19/2011	Start Qty: 20.00 Req'd Qty: 20.00			Cust Item II Customer:	D:						818 II 8 II 8 1 I 88 1
	Process Plan	n:	Date: <u>//- 6 7</u>	Tooling: SPC (Y/N):	Da	-			Run	Start Stop		
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr										
D3413	Rev .	A										
100 		FLOW WATER JET		0.00				BII	-8-3			
FLOW CNC Waterjet	4	Dwg Rev Prog Rev					E		, 58/19	i.		
110 		QC2- Inspect parts off	machine FAI/FAIB	0.00				{\bar{B}.1}	(-8-	3_		
Quality Control		Мето										

S Meel 22

0.00

120

Quality Control

QC8- Inspect parts - second check

Memo

Dart	Aeros	pace	Ltd
-------------	--------------	------	-----

Dart Ae	rospace	Ltd							i .
W/O:	:		W	ORK ORDER CHANGE	S				
DATE	STEP	PROC	EDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			s.				<u> </u>		
Part No	:	PAR #:	_ Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	_ Dispositio	n:	QA: N/C CI	osed:		Date: _	
NCR:		W	ORK ORD	ER NON-CONFORMA	NCE (NCF	1)			
DATE	CTED	Description of NC	Corrective Action Section B			Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC Inspector
					-				
[

Work ()rder	ID	72137
--------	-------	----	-------

Tuesday, July 19, 2011 12:44:44 PM



Page 2

Item ID:

D3413-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Ring

Start Oty: 20.00 7/19/2011

Req'd Qty: 20.00



Cust Item ID:

Customer:

Reference:

Start Date:

Process Plan:

Date:

Tooling:

Date:

Date:

Run

Start

Stop



Approvals:

Required Date: 7/25/2011

QC:

Date:

SPC (Y/N):

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Sequence ID/ **Work Center ID**

130

Small Fab

Small Fab

Operation Description

Memo

Memo

Memo

Small Fab

Set Up/ **Run Hours**

0.00

0.00

1- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1.

140

OC

Quality Control

QC5- Inspect part completeness to step on W/O

D W05/72

150

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

□FINISH TIME:

20x & m/ 1/100

START TIME: M117745

W/O:			14	(0.01/.000000.011.0						
			V\	ORK ORDER CHA	INGES					
DATE	STEP	PROC	EDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		•					;			
	` `									
							:			
Part No:		PAR #:	_ Fault Ca	legory:	NC	R: Yes I	No DQA	\:	Date: _	
	R	esolution:	_ Dispositi	ion:	QA	N/C Clo	sed:		Date: _	
NCR:		W	ORK ORI	DER NON-CONFO	RMANCE	(NCR))			
DATE	STEP	Description of NC			Section B	Ciara 0	Verific		Approval	Approval
		Section A	Initial Chief Eng	Action Descript Chief Eng	ion	Sign & Date	Section	n C	Chief Eng	QC Inspector
	10									
	į			•						
								· · · · · · · · · · · · · · · · · · ·		

Work Order ID 72137 Tuesday, July 19, 2011 12:44:44 PM

Page 3

Item ID:

D3413-1

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Required Date: 7/25/2011

Ring

QC:

7/19/2011

Start Qty: 20.00

Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Sequence ID/

Work Center ID

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject **Qty**

Reject Insp. Number Stamp

170

Packaging Packaging

Identify as per dwg & Stock Location: ST 467

QC21- Final Inspection - Work Order Release

0.00

Sp 11-08-29.

180

Quality Control

0.00

Memo

0.00

U 11.08/29

	-								
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								-	
							<u> </u>		
Part No		PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A :	Date: _	
	R	esolution:	Disposition	on:	_ QA: N/C CI	osed:		Date: _	
NCR:		\	WORK ORE	PER NON-CONFORMA	ANCE (NCF	R)			
DATE	STEP	Description of NC			ion B	Verific	ation	Approval	Approval
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Chief Eng	QC Inspector
		·							
1	1		1			1		1	1

Picklist Print

Tuesday, July 19, 2011 12:44:50 PM

Work Order ID: 72137

Parent Item: D3413-1

Parent Item Name: Ring

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A□05.09.13□New issue□KJ/JLM IPP Rev:B Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250X4.000		Purchased	No			100	f	24.0000	0.25	5.263158			
204 BAB 250 :: 4.00										1/B11-	8-3		

304 BAR .250 x 4.00

 Location
 Loc Qty
 Loc Code

 MAT009
 24

 118182
 24

<u>8182</u> · (

W/O:	Т		W	ORK ORDER CH	ANGES		···-	-		
DATE	STEP	PRO	ROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:								
NCR:	R	esolution:		DER NON-CONFO					Date: _	
HCA.	T			Corrective Action	Section B		<u></u>		<u> </u>	1
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description		Sign & Date	Verifica Section		Approval Chief Eng	Approval QC Inspector

DART AEROSPACE LTD	Work Order:	72/37
Description: Ring	Part Number:	D3413-1
Inspection Dwg: D3413 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.88	+/-0.030	3.866	¥		V 1802	
Ø2.00	+0.012/-0.001	2003	>		V	
0.75	+/-0.030	1748	>		V	
Ø0.266	+0.006/-0.001	.767	7		V,	
0.250	+/-0.010	-249	>		V	
		-				

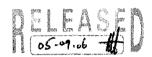
Measured by:	Audited by:	Prototype Approval: N/A	
Date: 11-8-3	Date: 11/08 22	Date: N/A	

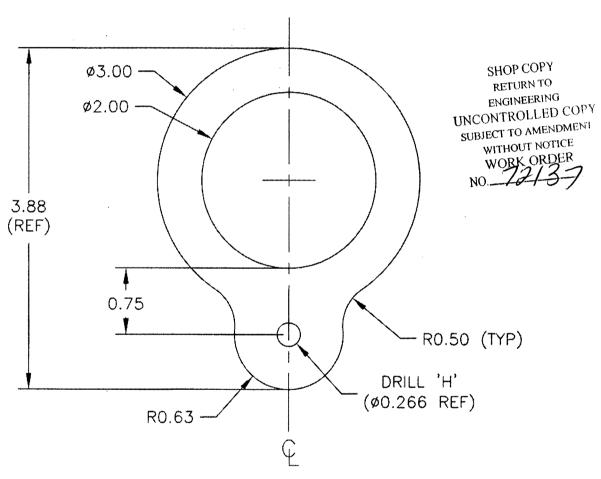
Rev	Date	Change	•	Revised by	Approved
Α	07.09.06	New Issue		KJ/JLM	E

	•										
W/O:			WC	RK ORDER CHANG	ES						
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
					ļ. 						
Part No:		PAR #:	Fault Cate	_ NCR: Ye	NCR: Yes No DQA: Date:						
	Res	olution:	Disposition:			Closed:	Date:				
NCR:			WORK ORD	R NON-CONFORM	ANCE (NC	R)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verif	Verification	Approval	Approval		
	JILI		Initial Chief Eng	Action Description Chief Eng	Sigr Dat		tion C	Chief Eng	QC Inspector		
								:			
								and the second s			
÷											
	l				l	į.		I			



200000000000000000000000000000000000000	DESIG	CP	DRAWN BY	DART	AEROSPACE PORT HADLOCK, V		INC.
	CHECH	KED M	APPROVED A	DRAWING NO.	~~~~	***************************************	REV. A
		th	- Ht	D3413		SHI	EET 1 OF 1
	DATE			TITLE			SCALE
	05.0	3.16		RING			1:1
	Α		05.03.16	NEW ISSU	JE		





D3413-1 RING

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

Copyright © 2005 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

- 4	oopaoo										
W/O:			W	ORK ORDER CHAI	NGES						
DATE	STEP	PRO	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							:		14 - 14 - 14 - 14 - 14 - 14 - 14 - 14 -		
									r		
· ·							-				
Part No:		PAR #:	Fault Category:N			NCR: Yes No DQA:_			Date:		
Resolution:			Disposition: QA			N/C CI	osed:	Date:			
NCR:			WORK ORE	DER NON-CONFOR	MANCE	(NCF	R)				
DATE	STEP	Description of NC	Corrective Action Section B				Verification		Approval	Approval	
	Section A		Initial Chief Eng			Sign 8	Section C		Chief Eng	QC Inspector	
									.		
					<u>.</u>						
					·						